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PROCEDURE TO SETUP ATL-1840E W/ FAGOR CNC CONTROL

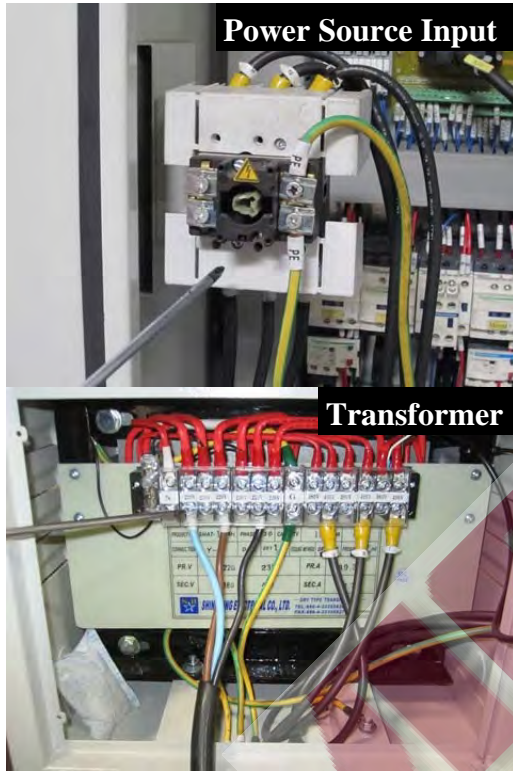
1. Unwrap the machine, check out machine for any physical damage. If so, report to your dealer as soon as possible. Touch-up paint is inside the toolbox. Use it as needed.

2. Remove two door lock screws on top of door. Remove steady rest.



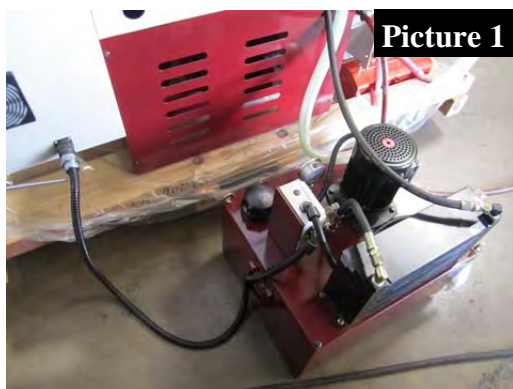
3. Check input power that will be used for the machine. Power required for our machines are: 230V three phase (3Φ) or 460V three phase (3Φ). Power must be first specified upon ordering. There is a transformer with the machine which converts power from 440V to 230V to run control when you order 460V power supply.

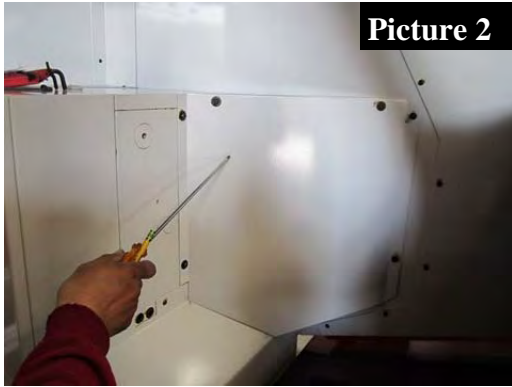
* If run on Fagor Driver, there is a transformer with the machine that converts 230V or 460V 3Φ to 400V only to run machine.



4. Before powering machine, open the electric enclosing cabinet. Make sure all wires and cables are correctly wired and are tight (see picture above).

5. Plug in spindle cooler cable (optional). Connect 2 Spindle Cooler Hose (picture 1). Loosen 4 screws & 2 nuts to take out cover (picture 2; turn on valve (picture 3).





Picture 2



Picture 3

6. Turn on main power switch (picture 4). Machine will start to load CNC software in about 30 seconds. Release emergency push button (picture 5). Turn on machine by pushing the green power on button (picture 6).



Picture 4



Picture 5



Picture 6

When you push the green button, the oil coolant pump will be on. Make sure that the rotation is clockwise, which means the 3 phase wiring is correct (picture 7). If the wiring is not correct, please shut down machine by reversing steps, press the emergency button (picture 5) and turn off main switch (picture 4). Switch any two power lines that go into the machine.



Picture 7

7. Home Machine: Push F4, Jog button (picture 8), then press F1, Reference Search (picture 9). Press X, F1, then the Execute button (picture 10), X will move towards operator then press Z, F2, then the Execute button. **Make sure there are no items in the way.** (The Z moves towards tailstock).



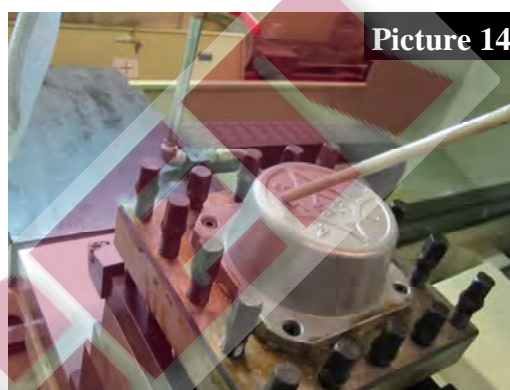
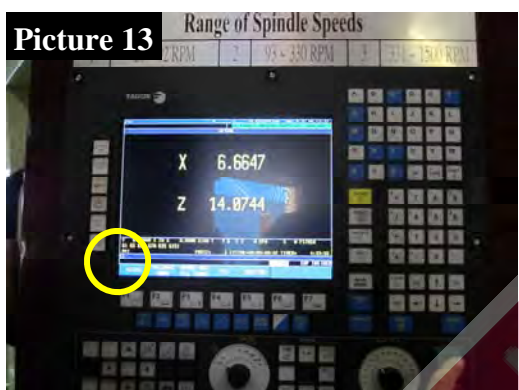
8. Manual Handwheel Test: Hit the ESC button, one time. Select, 1x, 10x or 100x. Move handwheel selector to 10x (picture 11). Move Z-, then move X-.



9. H4 Turret Testing: Press and hold Tool Jog CW (picture 12). Then press and hold Tool Jog Counter Clockwise.



10. Press MDI. Type T1 (picture 13), then press the Execute button. The type T3, then press the Execute button. Tool angles towards the part (picture 14).



11. Testing Spindle: Select MDI, F4. Type in S100M3 (picture 15). Press the Execute button. Type M5 and press the Execute button to stop spindle.



12. Changing RPM: Change to a different RPM Range. Type S400M3, then press the Execute button. Machine will auto shift to desired spindle range. Wait 5 seconds.

13. Leveling the machine

Precisely leveling the machine on a solid foundation. Precise leveling of the ATL-1840E is important to the finish of the product and the tolerance of the machine. Machine level in X and Y axes has to be within .0004/12” or better.



14. Warm-up spindle/ X, Z movement

It is recommended that customers should warm up machine by slowly running spindle rpm under 300 rpm and run machine with low feed rate for 15 minutes everyday before actually cutting anything.

The program can be written in the way that would help machine to “get ready” for production.

15. For auto lube pump, we recommend you to use way oil #2 or follow the manual suggestion.



16. Ready to run your CNC machine: please read through the Fagor manual to familiarize all G code/ M code and programming on the control. Call Fagor support 847-981-1500 ext 750 if you have any questions about the programming.

17. If you have any problems or questions, first call your dealer for quick questions and service. If dealer is unable to resolve your problem call Acer at 714-632- 9701 (CA) 732-752-9100 (NJ) or Fagor at 847-981-1500 ext 750 (technical support) for further assistance.

